

Date: Tuesday, 8/21/2007 3:42:53 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE SPACER		
Job Number	: 34174		Part Number	: D2935		
Estimate Number	: 11063		Drawing Number	: D2935 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 8/21/2007 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 8/28/2007 Qty: 60 Um: Each		
Previous Run	: 34003					
Written By	: <u>JLM</u>					
Checked & Approved By	: <u>JLM</u>					
Comment	: Est A 00.06.06 New Issue EC					
	: Est Rev:B Now 6061-T6 06-06-23 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet
Comment: Qty.: 0.0532 sf(s)/Unit Total : 3.1941 sf(s) Material: M6061-T6 0.080" Thick Batch <u>M104392</u>		
<u>SAD 07/08/22</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2935 Dwg Rev: <u>B</u> Prog Rev: <u>B</u>		
2-Deburr if necessary → <u>M107/08/24 (X62)</u> SAD 07/08/22		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
<u>SAD 07/08/22 62</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
<u>SP 07/08/24 (X62)</u>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		
<u>41 07-08-27 (62)</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 01/08/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: SADDLE SPACER
Job Number: 34174		Part Number: D2935
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION  <i>8/07/08/28(62)U</i>
7.0	PACKAGING 1 	PACKAGING RESOURCE #1  <i>8/07/08/28(62)U</i>
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 		
8.0	QC21 	FINAL INSPECTION/W/O RELEASE  <i>8/07/08/28(62)U 8/08/28</i>
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34174
Description: Saddle Spacer	Part Number:	D2935
Inspection Dwg: D2935	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

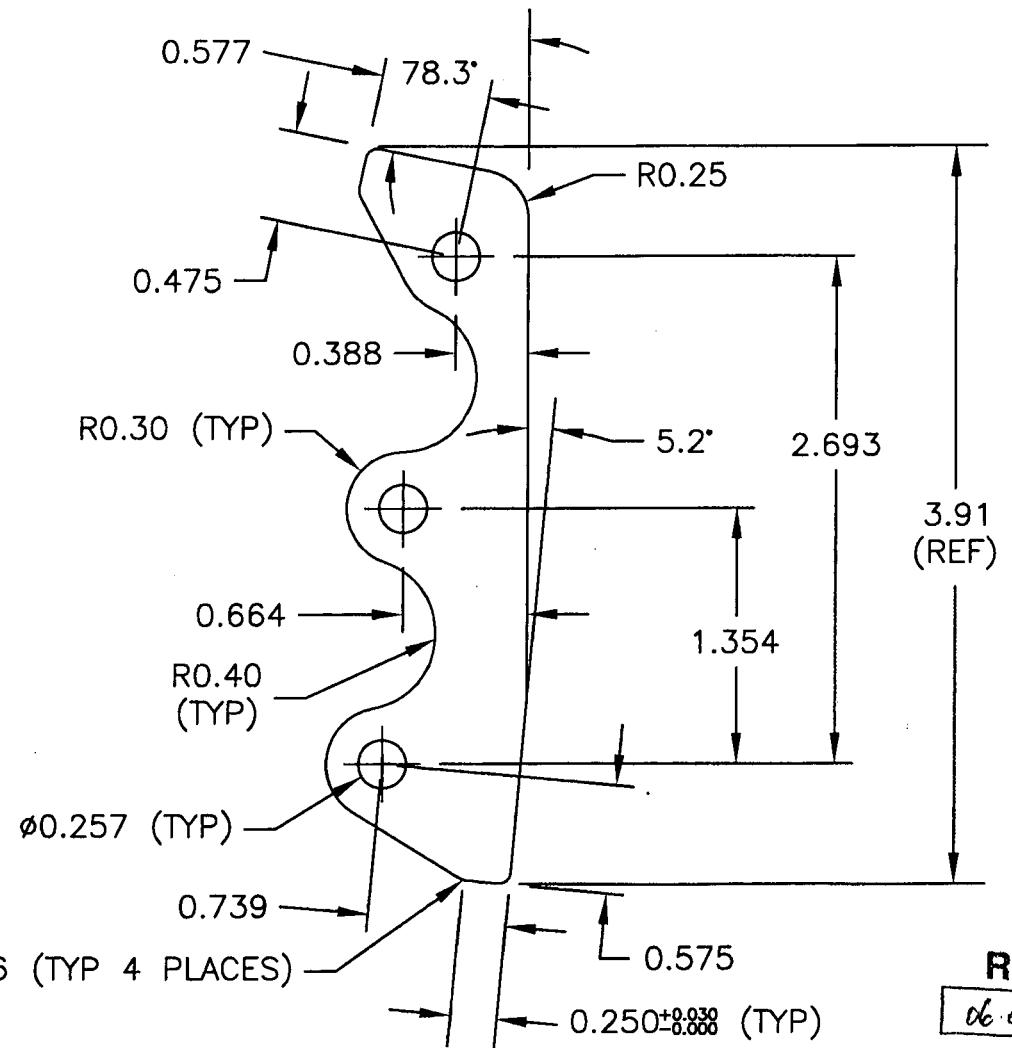
X First Article Prototype

Measured by: <u>SAD</u>	Audited by: <u>Er</u>	Prototype Approval:	N/A
Date: <u>07/08/22</u>	Date: <u>07/08/23</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.05	New Issue	KJ/JLM	
B	06.06.23	Dwg Rev. changed	KJ/JLM	<i>[Signature]</i>

DART

DESIGN <i>FF</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D2935	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC M5052H32S.080) SHOP COPY
RETURN TO
ENGINEERING
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 UNCONTROLLED COPY
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SUBJECT TO AMENDMENT
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020 WITHOUT NOTICE
- 5) ALL DIMENSIONS ARE IN INCHES WORK ORDER
NO. *34174*

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